

Work Order ID 157247

Friday, February 17, 2017 1:31:15 PM

157247

Page 1

Item ID: D3640-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Belt Guide

Start Date: 2/24/2017

Start Qty: 400

4

Cust Item ID:

Required Date: 3/10/2017

Req'd Qty: 400

4

Customer:

Reference:

Approvals:

Process Plan:

DAS
21
9-89

Date: FEB 22 2017

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3640

Rev A

100

0.00

100

BAND SAW

Bandsaw

Memo

0.03

Jeaspa Bandsaw

Cut blank 4.700 " long

10 10 17-03-09

110

0.34

110

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.05

HAAS CNC vertical machine #1

1- Mill as per Folio FA670 & Dwg D3640 Rev: A 2-Deburr and Blend
rad intersection with deburring tool.

10 10 17-03-10

120

0.00

120

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.01

Quality Control

10 10 17-03-10

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
								Completed By	
				Lead hand / Supervisor Approval Verification					
				QC / QA Coordinator Approval					

Root Cause				FAULT CATEGORY			
Environment ☐	☐ No Re-verification	Pressure/Forced ☐		Temperature/Cure ☐		Power Loss/Surge ☐	
Design ☐	Operator ☐	Bending ☐		Set-up ☐		Folio/Program ☐	
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐		BOM/Route ☐		Grain ☐	
Equip/Tooling ☐	Supplier ☐	Cracks ☐		Broken/Damage/Defect ☐		Weld ☐	
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐		Inspection Incomplete/Unqualified ☐		Wrong Stock Pulled ☐	
Material ☐	Use for Testing ☐	Cuffs ☐		Contamination ☐		Out of Sequence ☐	
Internal Transport ☐	Poor Information ☐	Crushing ☐		Countersink ☐		Off-set ☐	
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐		Cut Too Short ☐		Mislabeled ☐	
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐		Instructions Incomplete/Unclear ☐		Fit/Function ☐	
Substation ☐	Process Improvement ☐	Marks/Chatter ☐		Drill Holes ☐		Misaligned/off center ☐	
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____					
Misidentified ☐	Past Due ☐						

Work Order ID 157247

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Page 2

Item ID: D3640-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Belt Guide
Start Date: 2/24/2017 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 3/10/2017 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.01		B. P	17-03-11	10	0		DAS 08 9-89
140 *140* Packaging Packaging	Identify as per dwg & Stock Location: <u>Stock</u> Memo	0.00 0.01				10			DAS 6 9-89 MAR 13 2017
150 *150* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.07							17/3/14 MAR 13 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																																

Picklist Print

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Page 1

Work Order ID: 157247

157247

Parent Item: D3640-1

D3640-1

Parent Item Name: Belt Guide

Start Date: 2/24/2017

Required Date: 3/10/2017

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 07-01-15 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MDELRINB0.75X1.250		Purchased	No			100	f	16.0000	0.4	1.684211			

MDEI RINB0 75X1 250

Delrin Bar

Location

Loc Qty

Loc Code

MAT039

16

m134641

16

4

17-03-09

DQA: _____ Date: _____



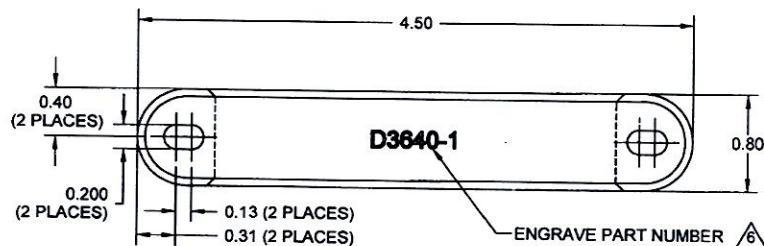
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

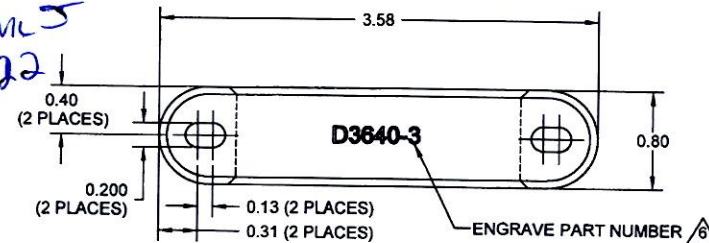
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

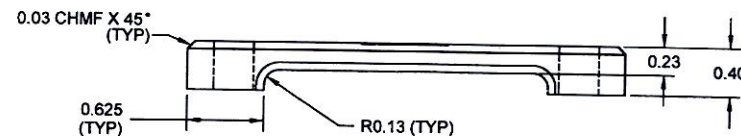
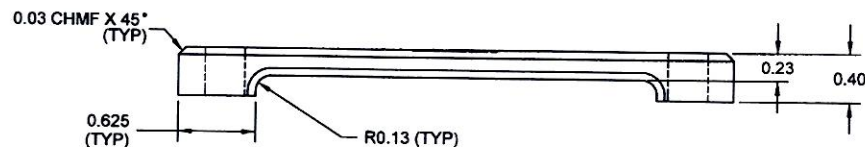
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 157247 MLJ
1702-22



D3640-1 BELT GUIDE
(WAS GENEVA P/N G10605-1)



D3640-3 BELT GUIDE
(WAS GENEVA P/N G10605-2)



- NOTES:
- 1) MATERIAL: BLACK DELRIN II 150E OR ACETRON GP ACETAL BAR (REF DART SPEC M-DELRIN-B)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: ENGRAVE PART NUMBERS TO MAX DEPTH OF 0.010 AT LOCATIONS SHOWN
 - 7) WEIGHT: 0.03 lbs



RELEASED
07.09.01

A		NEW ISSUE: REPLACES G10605		LE	07.07.27
REV.		DESCRIPTION		BY	DATE
DESIGN	TS	DART AEROSPACE USA, INC. PORT HADLOCK, WA			
DRAWN	LE				
CHECKED		DRAWING NO.		REV.	
MFG. APPR.		D3640		SHEET 1 OF 1	
APPROVED		TITLE		SCALE	
DE APPR.		BELT GUIDE		1	
DATE		COPYRIGHT © 2007 BY DART AEROSPACE USA, INC.			
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